

# Work Order ID - 66762

Friday, February 25, 2011 1:39:41 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-02-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

*8/10/06*

66762

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66762**

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Page 2

Item ID: D350-636-011

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

**Memo**

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 11/03/03

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Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: ☐ M116577/M111385

12-Grind welds flush as per Dwg D2750

> BE11/03/07

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S u l o r l o r

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S u l o r l o r

Memo

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

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1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

2. The second step is to analyze the problem. This involves identifying the causes of the problem and determining the impact of the problem on the company.

3. The third step is to develop a solution. This involves identifying the actions that need to be taken to address the problem and determining the resources that will be required.

4. The fourth step is to implement the solution. This involves putting the solution into action and monitoring the progress of the implementation.

5. The fifth step is to evaluate the results. This involves comparing the actual results with the expected results and determining the effectiveness of the solution.



**Abstract**

**Customer:**

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

**Abstract**

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**[illegible]

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## Quality Control

W/O:		WORK ORDER CHANGES					
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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	<b>Memo</b>	0.00							
	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>116040</u> exp. date: <u>11/09/30</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M116577</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

BB

11/03/10

BB

11/03/10

BE 11/03/17

BE 11/03/17

W/O:		WORK ORDER CHANGES					
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Page 6

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

BE 11/03/17

12-Deburr holes

BE 11/03/17

170

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Memo

0.00

S 11/03/17

Quality Control

180

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

S 11/03/17

Quality Control

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66762

Friday, February 25, 2011 1:39:42 PM



Page 7

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00				1		BR 11-3-22	
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00				1		BR 11-3-23	
Powder Coating	Memo START TIME: 7:15 OVEN TEMPERATURE: 320° FINISH TIME: 7:45								
210	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo Inspect for foreign object per QSI 024								

7 M-L

11/03/26



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 66762**

Friday, February 25, 2011 1:39:42 PM



Page 9

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Friday, February 25, 2011 1:39:42 PM



**Accept**

Revision ID:

**Item Name:** Skidtube LH

**Start Date:** 2/25/2011      **Start Qty:** 1.00

**Required Date: 3/11/2011      Req'd Qty: 1.00**

**Reference:**

**Cust Item ID:****Customer:****Setup Start**

**Stop**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**Stop**

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
Qty

**Reject  
Number**

**Insp.  
Stamp**

270

0.00

[illegible]

## Packaging

### Packaging

## Memo

0.00

## Packaging

Package as per PPP D350-636-011

NAV I

280

0.00

[illegible]

QC21- Final Inspection - Work Order Release

QC

## Memo

0.00

### Quality Control

Qty Qty Number Stamp

64/3/250

Q 11/03/28

mf

11-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:49 PM

Page 1

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec  
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verified by: EC IPP Rev: P 10.06.22  
 revise seq110 DD verf: EC IPP Rev: Q 10.10.01 as per IIN  
 revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 O-Ring, 205 Skidtube		Manufactured	No			230	Each	1,031.000	8	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				543					
				55546				19					
				58191				12					
				59358				12					
				65518 ✓				500					
				fpa				488					
				61762				488					
AN960JD816 1/2" washer, Alum		Purchased	No			250	Each	89.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST348				89					
				106043				89					

m-l 11/23/26

8x

h

106043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:49 PM

Page 2

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

55.0000

1

1



Cap



BE 11/03/07

Location

Loc Qty

Loc Code

LG

29

65086

29

ST

26

62715

26

D2600-3-BENT

Manufactured No

110

Each

6.0000

1

1



Extrusion Bent



BE 11/03/03

Location

Loc Qty

Loc Code

LG

6

61634

2

62764

1

64434

3

Manufactured No

160

Each

122.0000

8

8



Crossbolt Spacer



BE 11/03/07

Location

Loc Qty

Loc Code

LG

122

50281

10

57953

2

59111

10

61844

16

64003

84

505  
725

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 25, 2011 1:39:49 PM

Page 3

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

4.0000 1 1



350 I Beam



Location

Loc Qty

Loc Code

LG

4

64448

4

Manufactured No

160 Each

35.0000 4

D3490-3



Cross Bolt Spacer



BB 11/03/10  
BEM/03/17

Location

Loc Qty

Loc Code

LG

35

60294

1

63556

24

64006

10

Manufactured No

160 Each

61.0000 4

D3490-1



Cross Bolt Spacer



BEM/03/17

Location

Loc Qty

Loc Code

LG

61

59424

3

62450

48

64005

10

Purchased No

220 Each

3,945.000 38 38

ALS4-1032-225



Insert



m.p 11/03/26

Location

Loc Qty

Loc Code

PK011

3945

110768 ✓

3945

38x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:50 PM

Page 4

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230 Each

93.0000 8



Plug Assembly



m-l 11/03/26

## Location

## Loc Qty

## Loc Code

FP013

93

59114

1

62210

3

63994

29

65068

60

8X

D3793-3

Manufactured No

230 Each

20.0000 1



Wearshoe



m-l 11/03/26

## Location

## Loc Qty

## Loc Code

FP018

15

39479

1

39812

2

64447

12

FP18

4

61711

4

FP19

1

57947

1

IX

AN8C35A

Purchased No

230 Each

61.0000 1



BOLT



m-l 11/03/26

## Location

## Loc Qty

## Loc Code

ST345

25

116874

25

ST346

36

114442

5

115188

5

115960

26

IX

Friday, February 25, 2011 1:39:50 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

25.0000

1

1



Wearshoe

Location	Loc Qty	Loc Code
FP018	17	
39277	1	
39715 ✓	2	
64445	14	
FP18	8	
59151	1	
59630	1	
61710	6	



m-h 11/03/26

D3488-041

Manufactured No

230

Each

17.0000

1

1



Blade Fitting Assembly, LH

Location	Loc Qty	Loc Code
FG008	10	
62002	10	
FP18	7	
61689 ✓	7	



m-h 11/03/26

D3794-3

Manufactured No

230

Each

19.0000

1

1



Gasket

Location	Loc Qty	Loc Code
FP010	3	
39422	3	
FP10	15	
60826	1	
61712 ✓	14	
FP18	1	
59153	1	



m-h 11/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:50 PM

Page 6

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

97.0000

4

4



BOLT



m-l 11/03/26

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

95

111649

2

114653

1

115936 ✓

42

116874

50

L/X

MS21083C8

Purchased

No

230

Each

43.0000

1

1



NUT



m-l 11/03/26

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884 ✓

31

L/X

D3536-25

Manufactured

No

230

Each

24.0000

1

1



Gasket



m-l 11/03/26

Location

Loc Qty

Loc Code

FP

12

65903

12

FP12

9

64446 ✓

9

FP-12

3

39234

3

L/X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 25, 2011 1:39:50 PM

Page 7

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1  
Washer

Manufactured No

230 Each

144.0000 8 8

Location

Loc Qty

Loc Code

ST072

144

63647 ✓

144

230 Each

14.0000 1 1

D3791-1  
Wearplate

Manufactured No

Location

Loc Qty

Loc Code

FP017

3

39276 ✓

1

39418 ✓

2

FP17

11

62239

11

AN960C10L  
washer

NAS1149C0332  
R

Purchased No

230 Each

127.0000 38 38

Location

Loc Qty

Loc Code

ST245

127

107534

59

108246

68

D2745  
Bushing

Manufactured No

230 Each

121.0000 8 8

Location

Loc Qty

Loc Code

ST023

121

52311

5

59112

4

61988

4

63315 ✓

108

m-k 11/03/26

8x

m-k 11/03/26

1x

m-k 11/03/26

M116304 38x

m-k 11/03/26

8x

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3CSA

Purchased

No

230

Each

1,024.000

34

34



Bolt



m-p 11/03/26

## Location

## Loc Qty

## Loc Code

ST350

1024

107862

68

108302

34

114330

11

115015

13

115371

4

115422

100

115835

194

116419

500

116549

100

34x

D3537-1

Manufactured

No

230

Each

33.0000

3

3



Wearpad



m-p 11/03/26

## Location

## Loc Qty

## Loc Code

FP017

33

37749

6

65057

27

65927 3x

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER



m-p 11/03/26  
ix

NAS1149C08332R

114915

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:51 PM

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Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

41.0000

8

8



Plug Assembly



*m-l 11/03/26*

Location

Loc Qty

Loc Code

FP		2
54682		2
FP013		39
59117		1
59190		4
63996		2
65070	✓	32

AN3C6A

Purchased

No

230

Each

359.0000

4

4



BOLT



*m-l 11/03/26*

Location

Loc Qty

Loc Code

ST351		359
111982	✓	134
116419		75
116549		50
116704		100

NAS1611-013

Purchased

No

230

Each

248.0000

8

8



O-RING



*m-l 11/03/26*

Location

Loc Qty

Loc Code

FP		248
115460		100
115589		28
115812		20
116582	✓	100

*8x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:39:51 PM

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Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

21.0000



1 1  
m-l 11/03/26



Wearshoe

Location

Loc Qty

Loc Code

FP18

21

38867

1

39716

2

62233

6

65167

12

IX

D3794-1

Manufactured No

230 Each

15.0000



1 1  
m-l 11/03/26



Gasket

Location

Loc Qty

Loc Code

FP010

15

39279

1

39421

2

61704

12

IX

MS21043-6

Purchased No

230 Each

546.0000



4 4  
m-l 11/03/26



NUT

Location

Loc Qty

Loc Code

ST301

546

112314

546

L/X

D3493-1

Manufactured No

250 Each

32.0000



2 2



Washer

Location

Loc Qty

Loc Code

ST062

32

62677

32

62677

Friday, February 25, 2011 1:39:51 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 11

Friday, February 25, 2011 1:39:52 PM

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

43.0000

2

2



NUT

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884

31

115884

AN8C21A

Purchased

No

250

Each

71.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

71

113558

1

114653

2

115723

8

116381

60

116381

D3672-1

Manufactured

No

230

Each

1,077.000

8

8



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1077

42329

10

52505

67

64177

1000

42329

P.T.O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/28	230	ASSEMBLE WITH NASISISH3L / M 113362	M/A	11/03/28	4		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

Friday, February 25, 2011 1:39:52 PM

Work Order ID: 66762

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

79.0000

1

1



Blade, 350 Skidtube



Location

Loc Qty

Loc Code

ST466

79

60210

6

61341

33

63589

40

61341

D3532-1

Manufactured No

250 Each

31.0000

2

2



Spacer



Location

Loc Qty

Loc Code

ST065

31

62218

31

62218

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL  $\Delta$
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER  
NO. 66762  
PS11-02-25

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68 07 17

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<u>PH</u>		
CHECKED	<u>PH</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>PH</u>	D2750	SHEET 1 OF 11
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

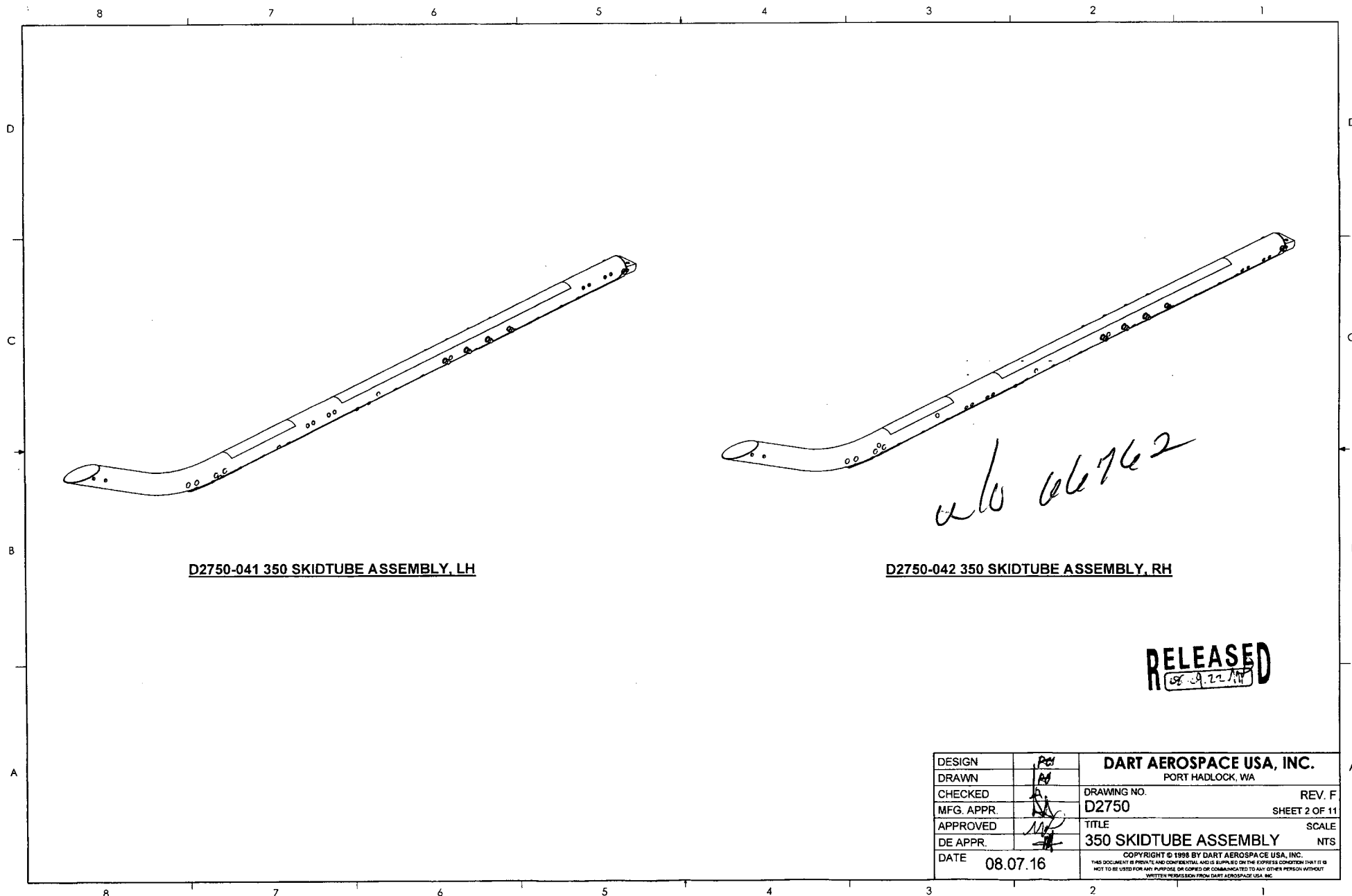
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries



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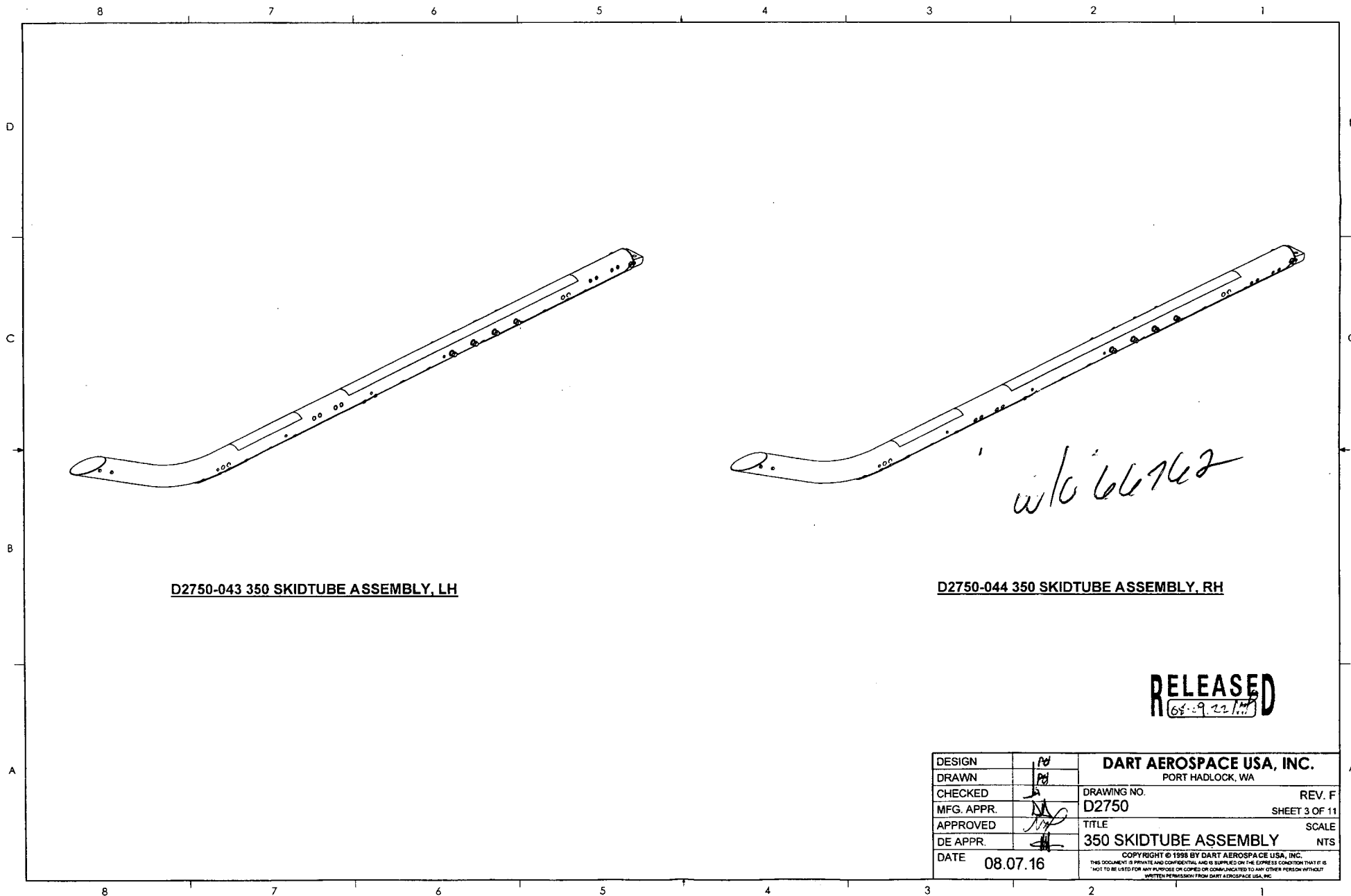
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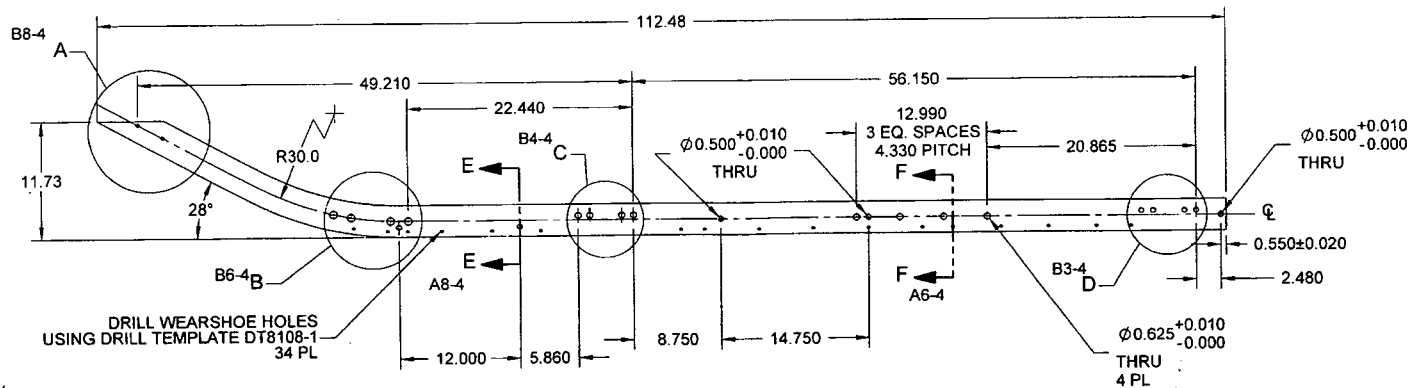
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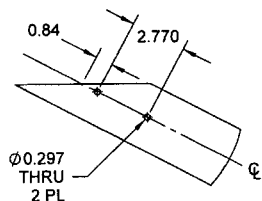
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

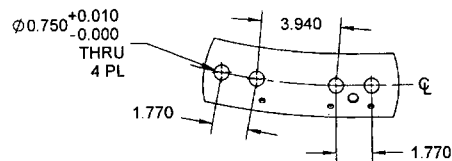
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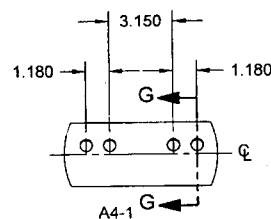
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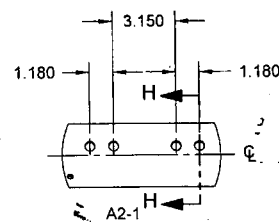
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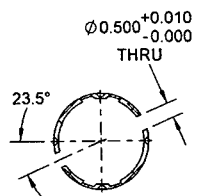
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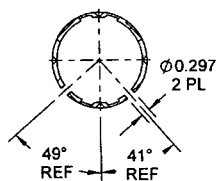
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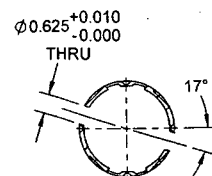
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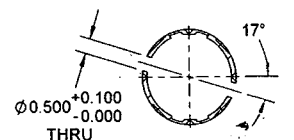
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

*u/b u/b 262*

**RELEASED**

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

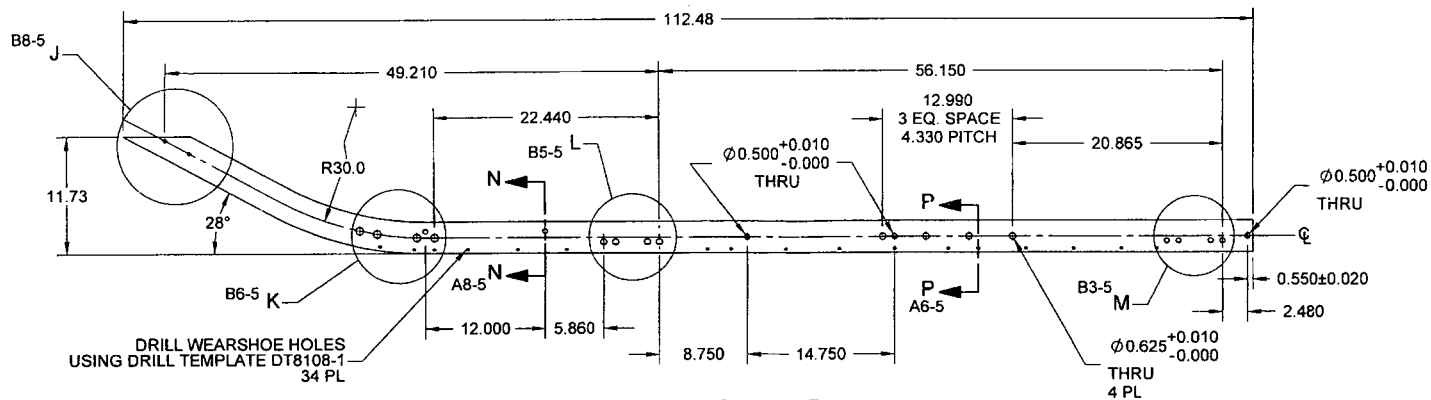
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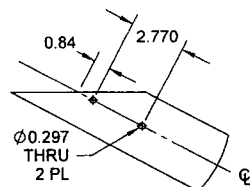
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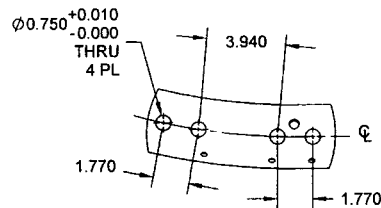
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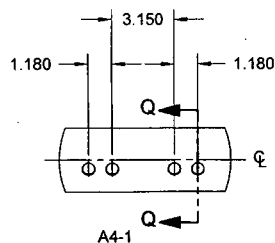
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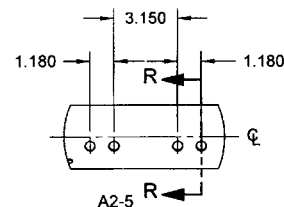
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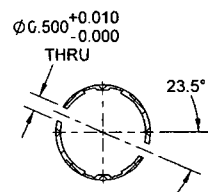
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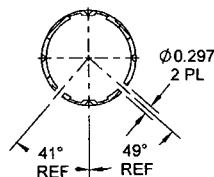
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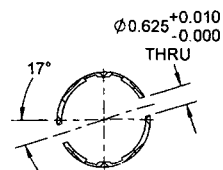
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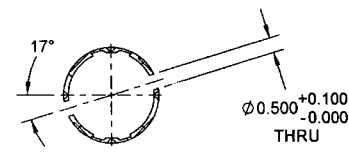
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

$\phi 0.500^{+0.100}_{-0.000}$   
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DESIGN	REV
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<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D2750</b>	REV. F
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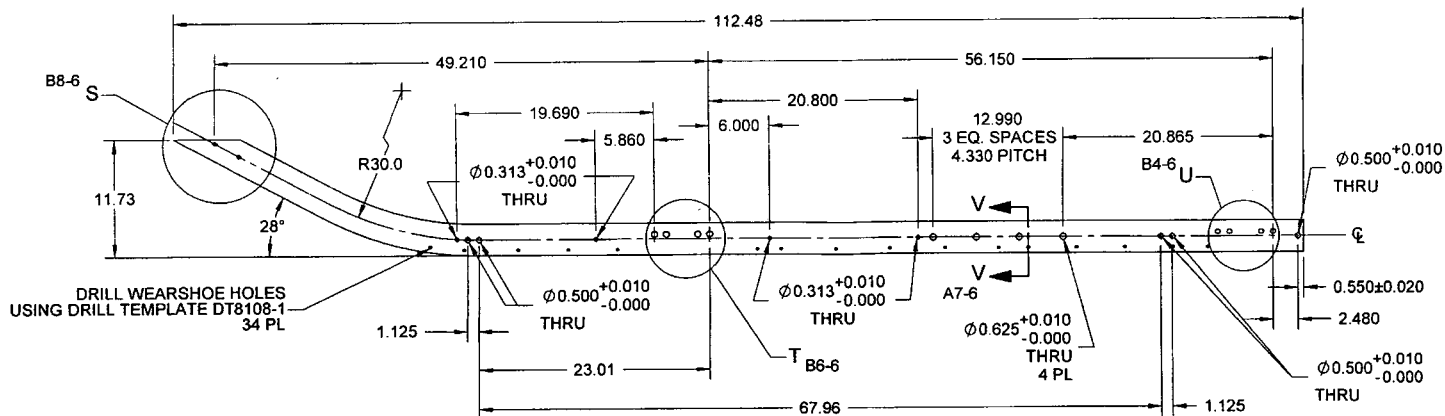
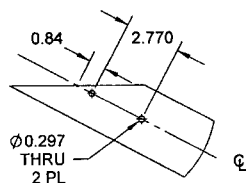
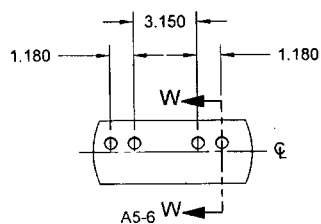
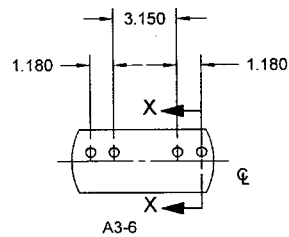
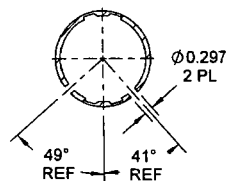
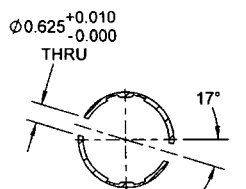
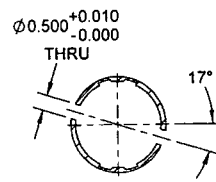
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
4

3

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1

**D2750-3 LH SKIDTUBE****DETAIL S**  
D8-6  
SCALE 2X**DETAIL T**  
C5-6  
SCALE 2X**DETAIL U**  
D3-6  
SCALE 2X**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL**RELEASED**

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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

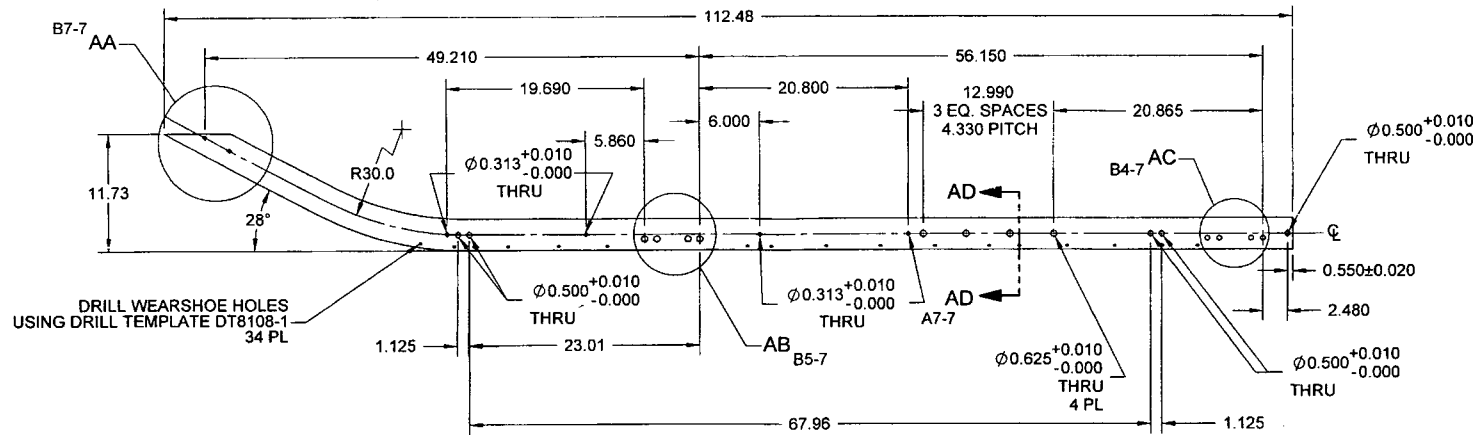
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

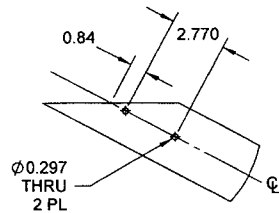
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

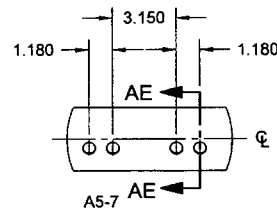




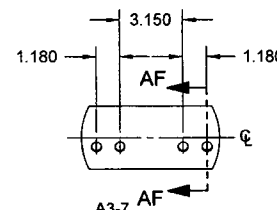
**D2750-4 RH SKIDTUBE**



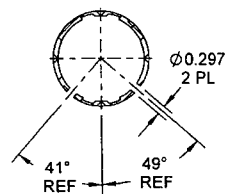
**DETAIL AA**  
SCALE 2X



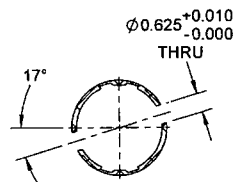
**DETAIL AB**  
SCALE 2X



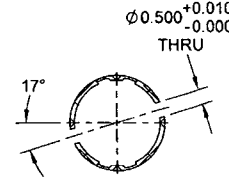
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*w/c hole #2*

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06-02-2010

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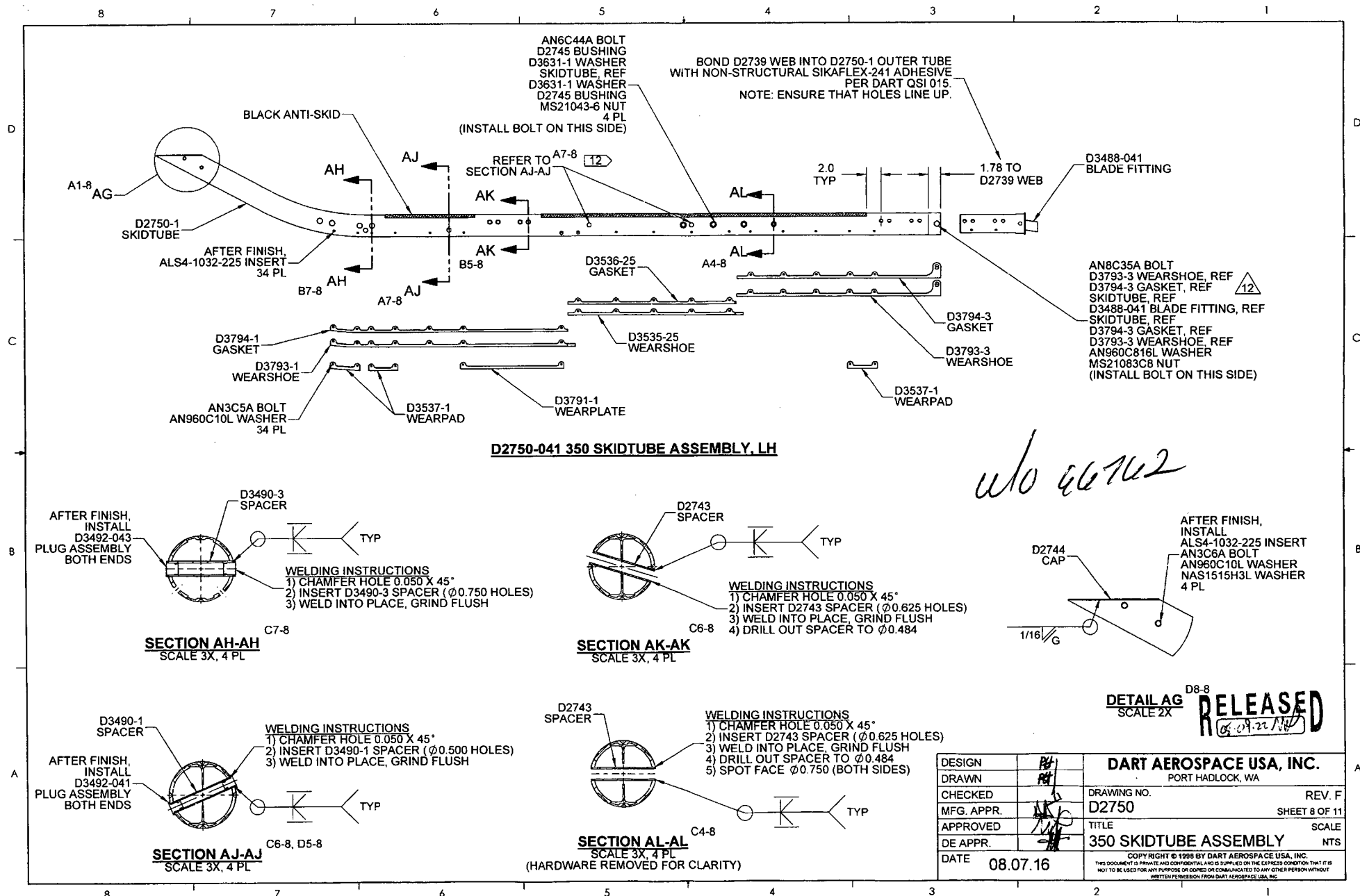
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

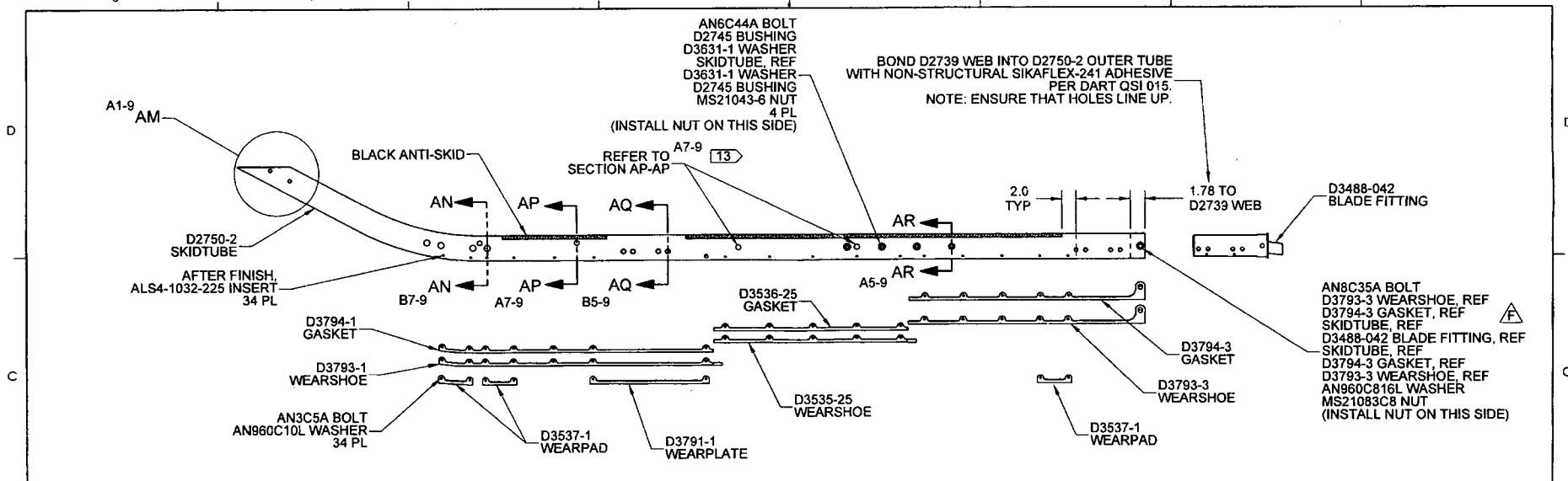
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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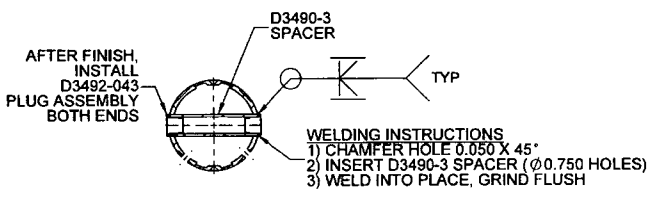
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

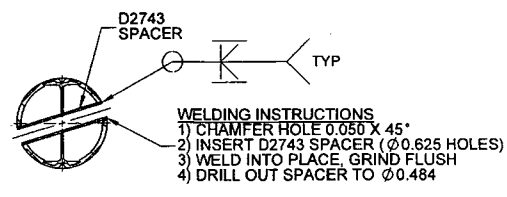


**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

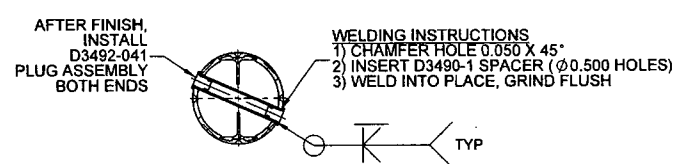
*u b 66742*



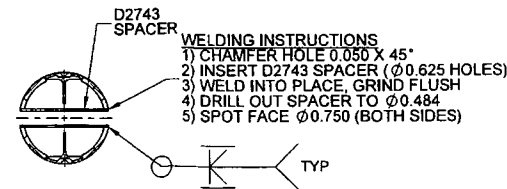
**SECTION AN-AN**  
SCALE 3X, 4 PL



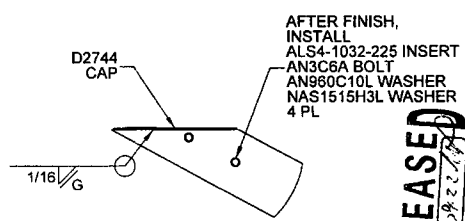
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AM**  
SCALE 2X

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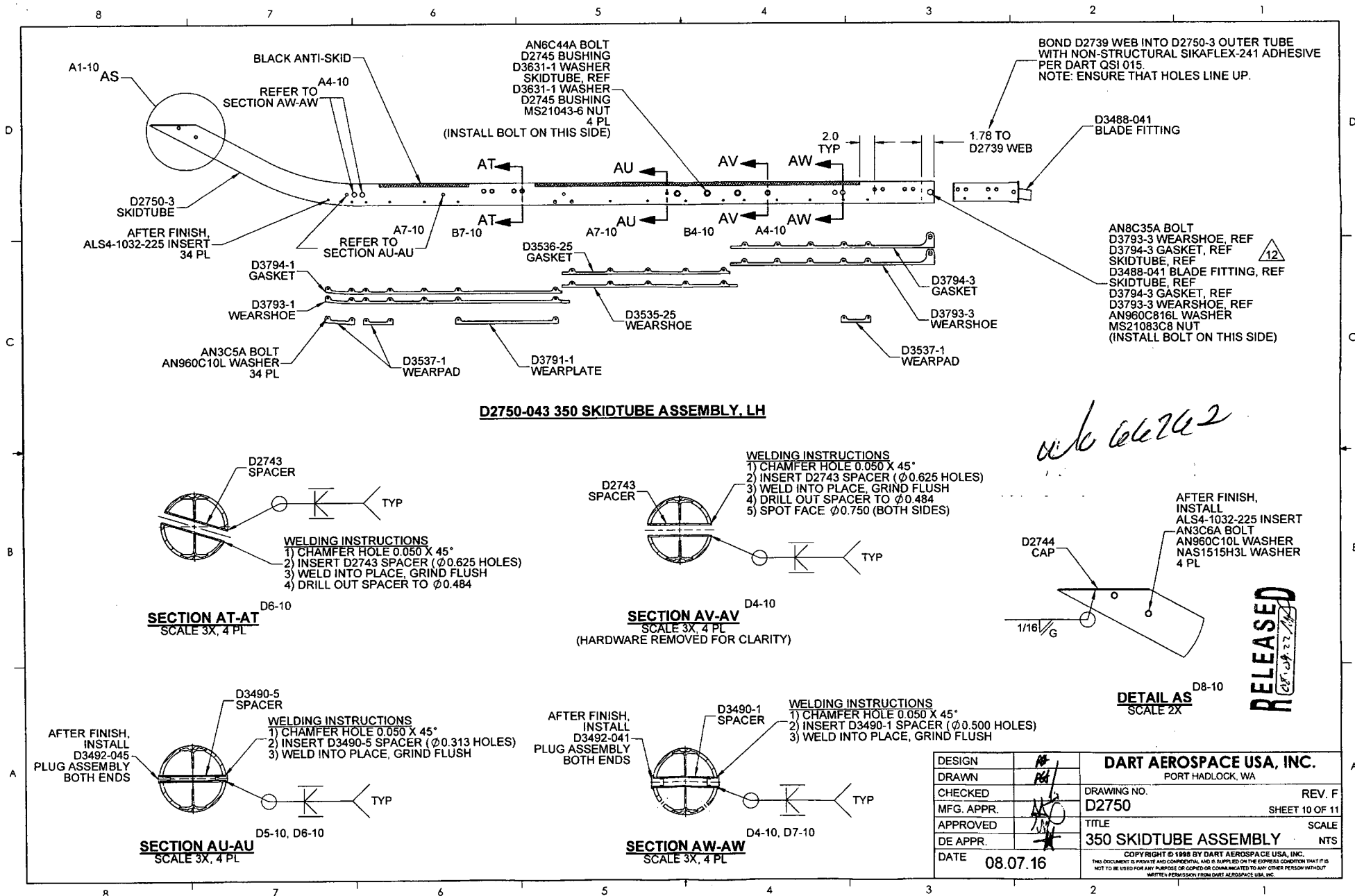
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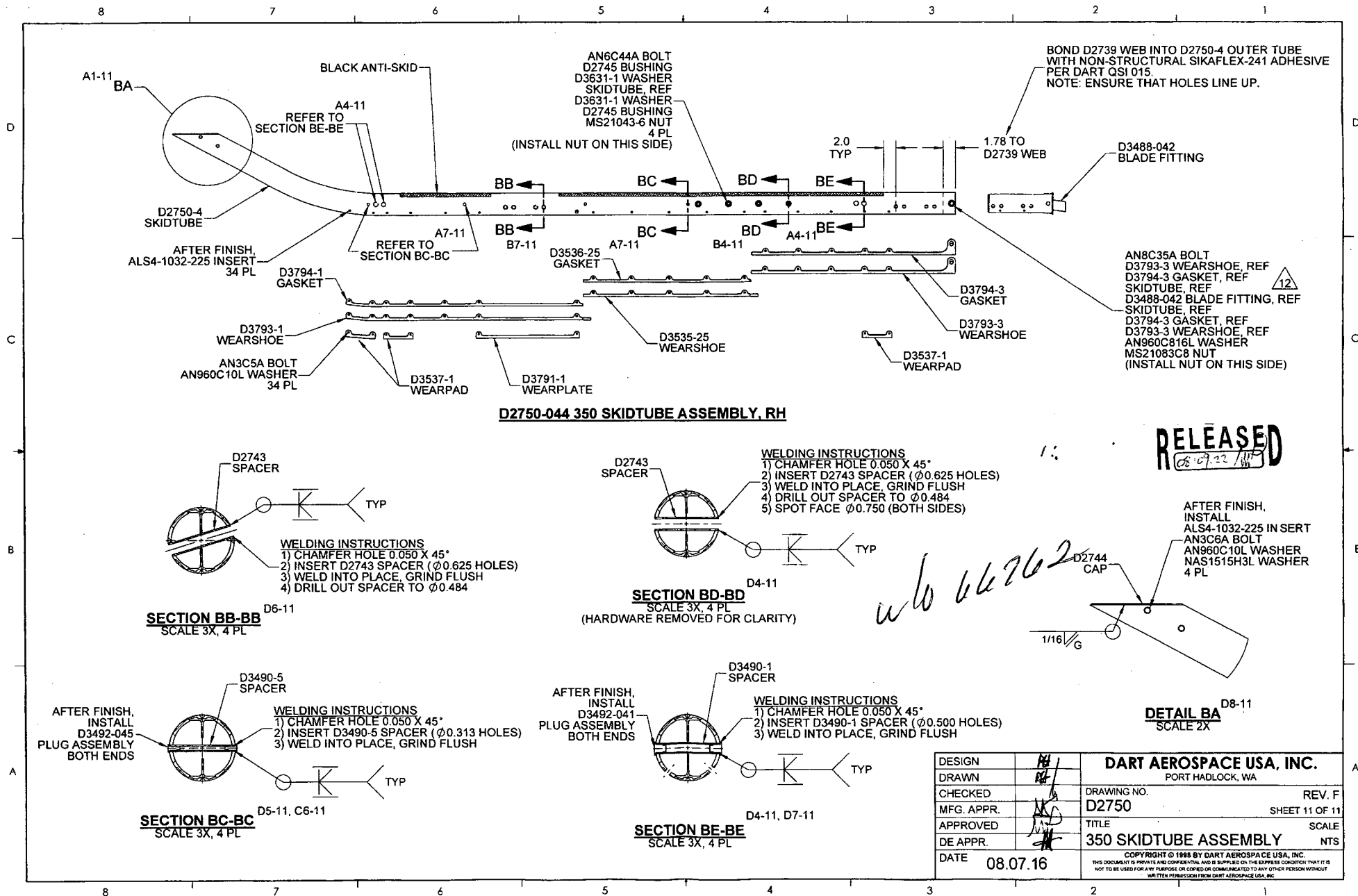
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 243

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barkley Elliott  
Job number: ~~64953~~ 64953  
Part number: S350-636-016  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier John Lewis Date of Test Coupon 11-01-18  
Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld